

Work Order ID 51206

August 8, 2009 7:16:42 AM



Page 1

Item ID: D205-770-011

Accept



Setup Start



Revision ID: A

Stop



Item Name: Replacement Engine Mount

Start Date: 08/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 08/14/2009 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: MF Date: 09-08-08 Tooling:

Date:

Run Start



QC: Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN D205-770

Rev A

B

0.00

100



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D205-770-011 CHG001

MF 09-08-12
~~MF 09-08-12~~

Sc 08/08/13

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

MD 09/08/12 +2

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

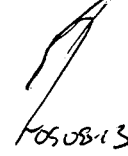

Quality Control

27 Sc 08/08/13

(+2)

\$

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05.08.13	W/O Leader	update dry box to Rev. B. perm change	EC	09.08.02		 05.08.13	 05.08.13

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51206

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Page 2

Item ID: D205-770-011

Accept



Setup Start



Revision ID: A

Stop



Item Name: Replacement Engine Mount

Start Date: 08/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 08/14/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D205-770-011 CHG001

Location: A
PPP Rev: _____

9/8/13 2050

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

MF 09-08-13
11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 51206

Parent Item: D205-770-011RevA

Parent Item Name: Replacement Engine Mount


Start Date: 08/10/2009

Required Date: 08/14/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C12A  Bolts		Purchased	No			110	Each	613.0000	8.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

613

106993

7

110155

2

110552

3

110584

68

111916

33

112314

500

D3684-043RevC 		Manufactured	No			110	Each	0.0000	2.0000			
---	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

MOUNT ASSEMBLY

D3684-045RevC 		Manufactured	No			110	Each	4.0000	2.0000			
---	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

LEG ASSEMBLY

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

4

50739

4

Main Warehouse

ST139A

4

D3685-041RevC 		Manufactured	No			110	Each	0.0000	2.0000			
---	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

BIPOD MOUNT ASSEMBLY

8x 112314 MO 09/08/13

2x 50719 MO 09/09/12

2x 50739 9/8/11 SCJ

2x 51154 MK 09-08-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

August 8, 2009 7:16:42 AM

Work Order ID: 51206

Parent Item: D205-770-011RevA

Parent Item Name: Replacement Engine Mount



Comments:

Start Date: 08/10/2009

Required Date: 08/14/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3686-041RevC 		Manufactured	No			110	Each	0.0000	2.0000			
MONOPOD ASSEMBLY												
D3692-1RevB 		Manufactured	No			110	Each	66.0000	8.0000			
SPACER												

2x 51157 WF 09-08-12

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

66

44827

28

45672

38

8 x 50325 MD 09/08/13

MS21043-3

Purchased

No

110

Each

5,570.000

4.0000

Nut

Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG

80

103691

80

Main Warehouse

ST

5490

111819

190

112243

300

112314

5000

4 x 111819 MD 09/08/13

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

The following is the net weight increase associated with the D205-770-011 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-770-011 Replacement Engine Mount Kit	14.6 lb 6.62 kg	-3.5 in -0.09 m	-51.1 in-lb -0.6 m-kg	107.8 in 2.74 m	1574 in-lb 18.1 m-kg

5. PARTS LIST

Qty -011	Part Number	Description
X	D205-770-011	REPLACEMENT ENGINE MOUNT KIT
1	D3684-041	TRIPOD MOUNT ASSEMBLY
1	*D3684-043	MOUNT ASSEMBLY
8	**D3692-1	SPACER
4	**AN3C-12A	BOLT
4	**MS21043-3	NUT
1	**D3687-1	MOUNT
1	**D3684-047	FWD LEG ASSEMBLY
1	***D3688-1	STUD
1	***D3689-1	SLEEVE
1	***D3691-1	STUD
4	***D3692-1	SPACER
1	***D3693-1	ROD END BEARING
2	***AN3C-12A	BOLT
2	***MS21043-3	NUT
1	***NAS509-12C	NUT
1	***NAS509L-12C	NUT
1	**D3684-049	AFT LEG ASSEMBLY
1	***D3688-3	STUD
1	***D3689-1	SLEEVE
1	***D3691-1	STUD
4	***D3692-1	SPACER
1	***D3693-1	ROD END BEARING
2	***AN3C-12A	BOLT
2	***MS21043-3	NUT
1	***NAS509-12C	NUT
1	***NAS509L-12C	NUT
1	*D3684-045	INBOARD LEG ASSEMBLY
1	**D3688-5	STUD
1	**D3689-1	SLEEVE
1	**D3691-1	STUD
4	**D3692-1	SPACER
1	**D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	**NAS509-12C	NUT
1	**NAS509L-12C	NUT
4	*D3692-1	SPACER
2	*AN3C-12A	BOLT
2	*MS21043-3	NUT

W105 1200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1	D3685-041	BIPOD MOUNT ASSEMBLY
1	*D3687-3	MOUNT
1	*D3684-047	FWD LEG ASSEMBLY
1	**D3688-1	STUD
1	**D3689-1	SLEEVE
1	**D3691-1	STUD
4	**D3692-1	SPACER
1	**D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	**NAS509-12C	NUT
1	**NAS509L-12C	NUT
1	*D3684-049	AFT LEG ASSEMBLY
1	**D3688-3	STUD
1	**D3689-1	SLEEVE
1	**D3691-1	STUD
4	**D3692-1	SPACER
1	**D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	**NAS509-12C	NUT
1	**NAS509L-12C	NUT
8	*D3692-1	SPACER
4	*AN3C-12A	BOLT
4	*MS21043-3	NUT
1	D3686-041	MONOPOD ASSEMBLY
1	*D3688-7	STUD
1	*D3689-1	SLEEVE
1	*D3691-1	STUD
4	*D3692-1	SPACER
4	*D3692-3	SPACER
1	*D3693-1	ROD END BEARING
1	*D3693-3	ROD END BEARING
2	*AN3C-10A	BOLT
2	*AN3C-12A	BOLT
4	*MS21043-3	NUT
1	*NAS509-12C	NUT
1	*NAS509L-12C	NUT

(NOTE: PARTS IN BOLD TYPE CONSTITUTE PICK LIST FOR D205-770-011 KIT)

* PART IS INCLUDED WITH ASSEMBLY ABOVE

** PART IS INCLUDED WITH ASSEMBLY ABOVE

*** PART IS INCLUDED WITH ASSEMBLY ABOVE

W40 S1206

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Revision: **B**

Date: 08.12.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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